

Work Order ID 51989

September 11, 2009 9:00:39 AM



Page 1

Item ID: D3884-1

Accept



Setup Start



Revision ID: B

Item Name: Saddle, Inboard LH

Stop



Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 09-09-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3884

B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

0.00

HAAS CNC vertical machine #1

Memo

Program Batch No. 51989

Double check by: _____

1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA818 and inspect per Dimension Sheets

SL 09/10/27

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

0.00

Quality Control

Memo

SL 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51989

September 11, 2009 9:00:39 AM



Page 2

Item ID:	D3884-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Saddle, Inboard LH					
Start Date:	09/14/2009	Start Qty:	4.00		Cust Item ID:	
Required Date:	09/23/2009	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SF 09/10/28			4	0		
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	H 09/10/28			(X4) Ø			
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112140 Memo START TIME: 9:00AM OVEN TEMPERATURE: 320°F FINISH TIME: 9:30 AM	0.00 0.00	H 09/10/28			(24) Ø			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 51989

September 11, 2009 9:00:39 AM



Page 3

Item ID: D3884-1

Accept



Setup Start



Revision ID: B

Item Name: Saddle, Inboard LH

Stop



Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

MO 09/10/28

x4

160



Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

9/10/28 40 SP

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/28 RJ
PL 09-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 11, 2009 9:00:38 AM

Page 1

Work Order ID: 51989



Parent Item: D3884-1RevB



Parent Item Name: Saddle, Inboard LH

Start Date: 09/14/2009

Required Date: 09/23/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-017RevB		Manufactured	No			100	Each	0.0000	4.0000			

Saddle Billet

B 51835

X4

SL 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51989
Description: Saddle, Inboard, LH		Part Number: D3884-1
Inspection Dwg: D3884	Rev. B	Page 1 of 1

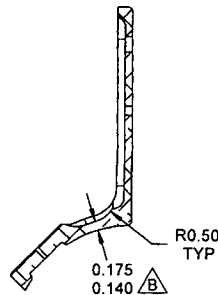
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.646	.647	.644	.645		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.613	.612	.610	.610		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.002	2.005	2.005		
J	0.140	0.175		.155	.151	.154	.155		
K	1.265	1.285		1.266	1.268	1.270	1.270		
L	0.115	0.135		.124	.121	.122	.123		
M	0.240	0.260		.249	.250	.249	.250		
N	0.110	0.140		.130	.130	.130	.130		
O	0.240	0.260		.258	.257	.254	.255		
P	2.826	2.886		2.867	2.867	2.867	2.867		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.154	.152	.152	.152		
S	0.720	0.780		.760	.760	.760	.760		
T	1.220	1.280		1.253	1.253	1.253	1.253		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		5.999	5.999	5.999	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.500	.501	.501	.501		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.316	.316	.316	.316		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.320	.320	.320	.320		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.001	.999	.999	.999		
AF									
Accept/Reject									

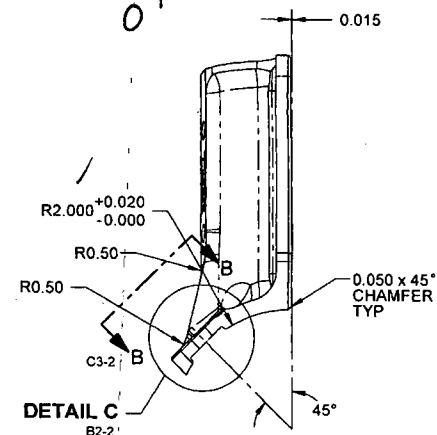
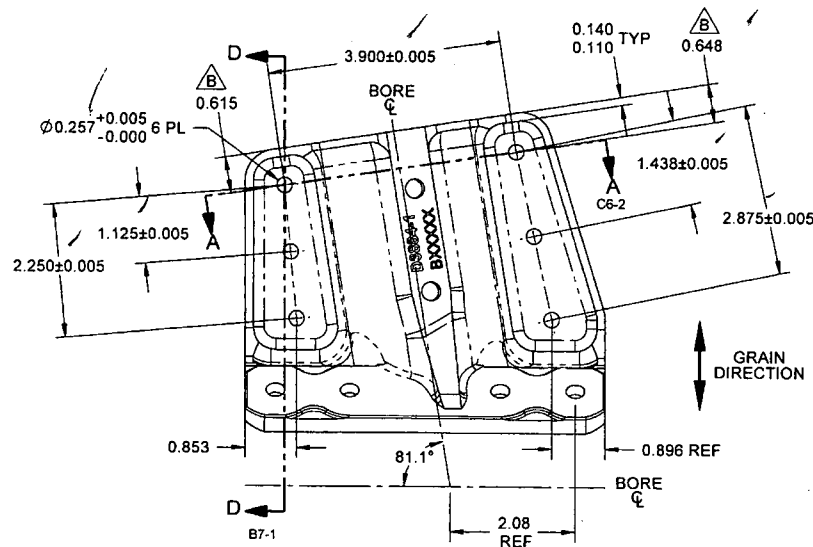
Measured by:	SL
Date:	09/10/24

Audited by:	SP
Date:	09/10/24

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	



SECTION D-D B6-1



DETAIL C
B2-2

RELEASED
07/15/14

**D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)**

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.515. ZN C6-1; ADD 0.848. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.080. ZN C2-2; 0.75 WAS 0.65. ZN D7-2		RF	09.06.30
	A NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	RF			
CHECKED	RF	DRAWING NO. D3884		REV. B
MFG. APPR.		TITLE		SHEET 1 OF 2
APPROVED		INBOARD SADDLE		SCALE
DE APPR.				NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

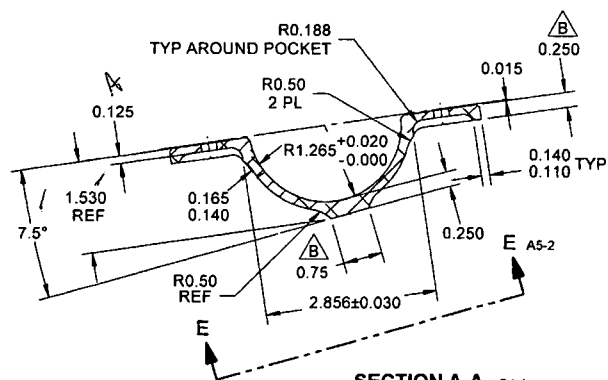
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

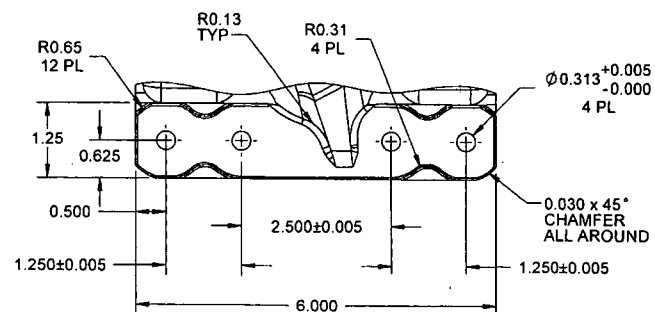
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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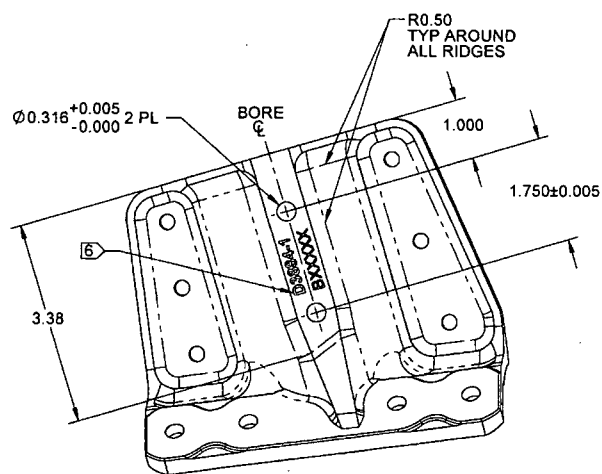
NOTE: Date & initial all entries



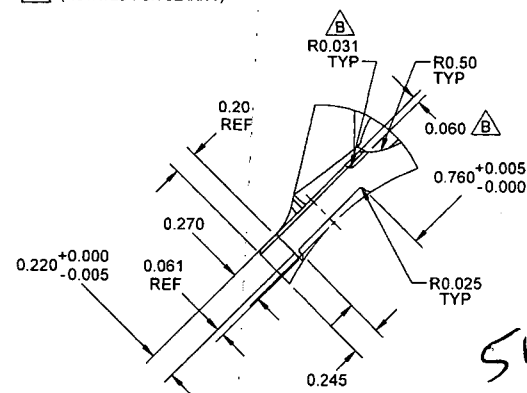
SECTION A-A C4-1



VIEW B-B B3-1
(ROTATED FOR CLARITY)



VIEW E-E C6-2



DETAIL C B3-1
SCALE 2X

RELEASED
29/07/15/110

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3884	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	INBOARD SADDLE	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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